

**Work Order ID 56228**

February 16, 2010 3:07:20 PM



Page 1

Item ID: D4010-041

Accept



Setup Start



Revision ID:

Item Name: Bearpaw Assembly

Stop



Start Date: 2/16/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/16/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4010-041

C

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

Pick Kit

110

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1- Use wearbar to transfer drill hole and open to finish size as per dwg  
 2- Deburr  
 3- Assemble as per Dwg D4010

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4010-041

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Start Date: 2/16/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/16/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130



QC

Quality Control

Operation  
Description

QC5- Inspect part completeness to step on W/O

Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

2/16/16

0.00

140



Packaging

Packaging

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

10-2-16 SP

0.00

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/02/16 JJ

MF 10-2-16

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Work Order ID: 56228



Parent Item: D4010-041



Parent Item Name: Bearpaw Assembly

Start Date: 2/16/10

Required Date: 2/16/10

Comments: IPP RevB: 09/11/03 Drawing changed to accomidate OEM and Dart Skidtube.  
DL. Verified by:DD IPP Rev. C Dwg.  
Redesign 09/11/012 DL VERIFIED BY:DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ AN3C5A	Replacement	Mfg/ Purchased	Bin	Primary No	Last	Route 100	Unit of Each	Qty on 564.0000	Remaining 5.0000	Qty	Date	Status

Bolt



<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

ST	564	
111424	8	
111707	69	
112314	1	
113121	206	5
113149	274	
113644	6	

D3456-1



Manufactured

No

100 Each 188.0000 3.0000



Washer

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

ST	188	
51653	7	
54692	181	3

BB  
10/02/16

BB  
10/02/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 56228



Parent Item: D4010-041



Parent Item Name: Bearpaw Assembly

Start Date: 2/16/10

Required Date: 2/16/10

Comments: IPP RevB: 09/11/03 Drawing changed to accomidate OEM and Dart Skidtube.  
DL. Verified by:DD  
Redesign 09/11/12 DL VERIFIED BY:DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/ Manufactured	Bin	Primary No	Last	Route	Unit of Each	Qty on 3.0000	Remaining 1.0000	Qty	Date	Status
D4010-1						100						



Bearpaw

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST  
53879

3

3

1

D4013-041



Wearplate Assembly

Manufactured No

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST  
53880  
54444

18

8

10

1

\_\_\_\_\_

BB  
10/62/16

Main Warehouse

ST256

8

\_\_\_\_\_

BB  
100246  
X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Bearpaw Assembly

Start Date: 2/16/10

Required Date: 2/16/10

Comments: IPP RevB: 09/11/03 Drawing changed to accomidate OEM and Dart Skidtube.  
DL. Verified by:DD IPP Rev. C Dwg.  
Redesign 09/11/02 DL VERIFIED BY:DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/ Manufactured	Bin	Primary No	Last	Route 100	Unit of Each	Qty on 105.0000	Remaining 5.0000	Qty	Date	Status
D4015-041												

Wearbar Weldment

## Warehouse

### Location

Main Warehouse

ST 104

53818 11

53956 93

Main Warehouse

therm 1

53818 1

MS21043-3



Purchased No

100 Each 4,322.000 5.0000



BB  
10/02/16

Nut

## Warehouse

### Location

OFFSHORE

FG 80

103691 80

Main Warehouse

ST 4242

111819 70

112243 29

112314 4143

3

BB  
10/02/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Bearpaw Assembly

Start Date: 2/16/10

Required Date: 2/16/10

Comments: IPP RevB: 09/11/03 Drawing changed to accomidate OEM and Dart Skidtube.  
DL. Verified by:DD IPP Rev. C Dwg.  
Redesign 09/11/02 DL VERIFIED BY:DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/ Purchased	Bin	Primary No	Last	Route 100	Unit of Each	Qty on 544.0000	Remaining 3.0000	Qty	Date	Status
MS21043-4												

Nut

## Warehouse

### Location

#### OFFSHORE

FG	40	
104603	40	

#### Main Warehouse

ST	504	
112243	2	
112314	103	3
112492	11	
113064	388	

BB  
10/02/16

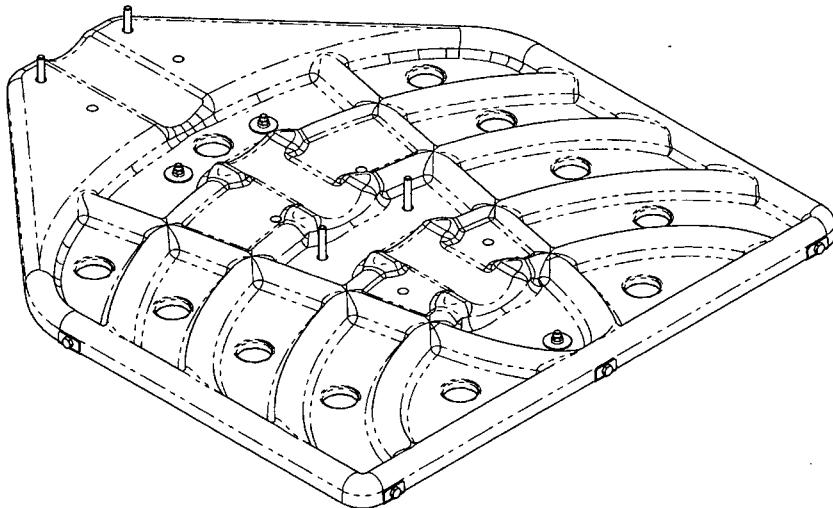
W/O:		WORK ORDER CHANGES					
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D4010-041 BEARPAW ASSEMBLY (407)

**RELEASED**  
2009-11-26  
M

C	OPTIMIZED DESIGN BASED ON FUNCTIONALITY AND TO EASE MANUFACTURING	MB	09.11.10
B	REDESIGNED, ADDED PROVISIONS FOR COMPATIBILITY WITH OEM SKIDTUBES/SADDLES; REDEFINED SOME TOLERANCE	MB	09.11.02
A	NEW ISSUE	MB	09.10.22
REV.	DESCRIPTION		
DESIGN	DART AEROSPACE LTD		
DRAWN	HAWKESBURY, ONTARIO, CANADA		
CHECKED	DRAWING NO. D4010		
MFG. APPR.	REV. C		
APPROVED	SHEET 1 OF 3		
DE APPR.	TITLE BEARPAW (407)		
DATE 09.11.10	SCALE NTS		
COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

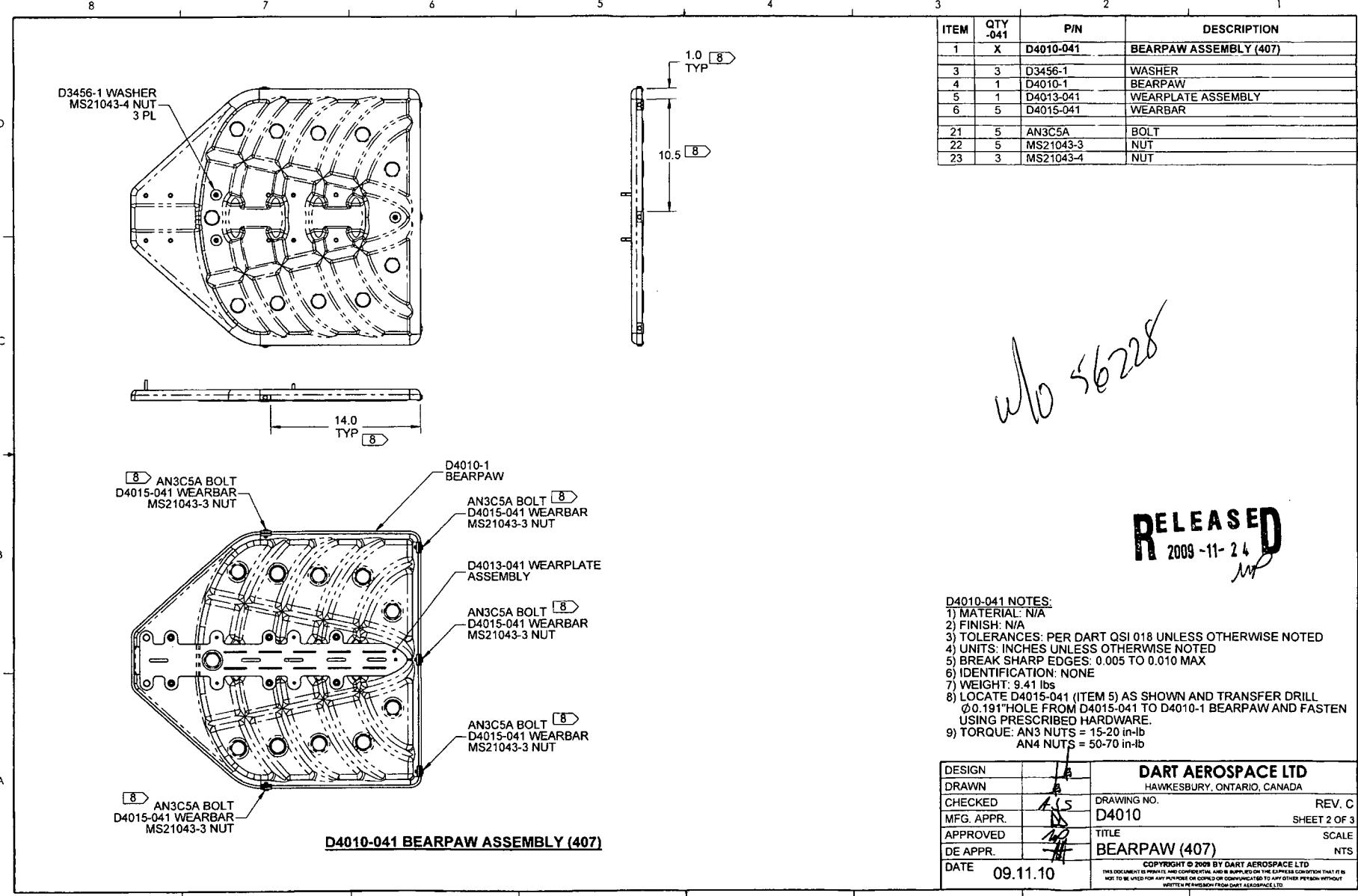
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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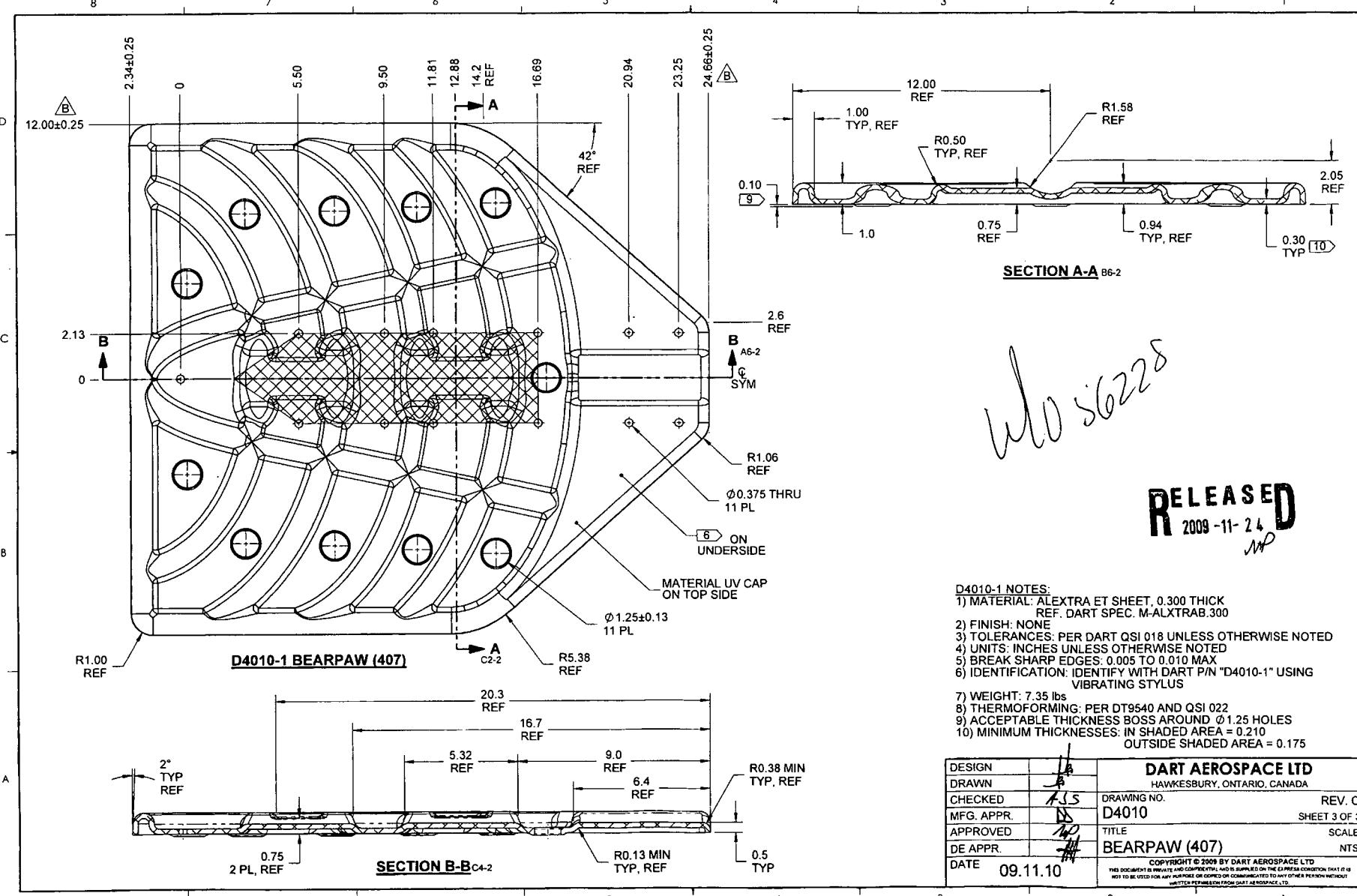
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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